

[0017] The upper surface 60 of the base portion 28 of the first mandrel 24 has a groove 61 extending radially inwardly from the upper end of one of the vertical feed passages 47 to the longitudinal axis A of the die. The lower surface 64 of the base portion 58 of the mandrel 54 has a complementary groove 66 forming a horizontal passage 68 with the groove 62. At its radially outer end, the horizontal passage 68 communicates with the top of the relevant vertical passage 47, and at the longitudinal axis A communicates with a short vertical passage 70 in the base portion 58. The base portion 58 also has a circumferentially extending series of transverse feed passages 72 (only one of which is shown) extending in a radially outwardly and slightly upwardly inclined manner from the upper end of the vertical passage 70, each feed passage 72 extending to the lower end of a respective one of the helical grooves 62. The second mandrel 54 is bolted to the first mandrel 24 by circumferentially spaced bolts 74 (only one of which is shown).